



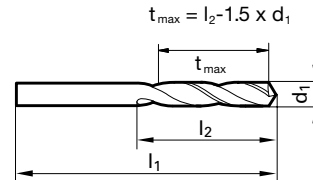
Tool material

HSCO

Surface



- | | | | |
|----------|-----------------|---|---|
| P | Steel | ● | web thinning ≥ Ø 1.000 • facet split point • Co-alloyed high speed steel • low feed force required • low torque required • for universal application |
| M | Stainless steel | ● | |
| K | Cast iron | ● | alloyed/unalloyed steels up to 800 N/mm ² • cold/hot work steels • antifriction bearing steels • non-ferrous metals • cast materials • stainless steels • plastics |
| N | Aluminum | ● | |
| S | Titanium alloys | ● | |
| H | Hardened steel | ● | |
- =Optimal
○=Limited



Speeds and feeds information on pg. 576

Shank diameter = cut diameter

Diameter (d ₁)		l ₁ mm	t _{max} mm	l ₂ mm	EDP #	
inch	wire/ltr mm					
0.0394	1.00	26.00	4.50	6.00	9055240010000	
0.0402	1.02	26.00	4.47	6.00	9055240010200	
0.0409	1.04	26.00	4.44	6.00	9055240010400	
0.0421	1.07	28.00	5.40	7.00	9055240010700	
0.0429	1.09	28.00	5.37	7.00	9055240010900	
0.0433	1.10	28.00	5.35	7.00	9055240011000	
0.0465	1.18	28.00	5.23	7.00	9055240011800	
0.0469	3/64	1.19	30.00	6.22	8.00	9055240011900
0.0472	1.20	30.00	6.20	8.00	9055240012000	
0.0512	1.30	30.00	6.05	8.00	9055240013000	
0.0520	1.32	30.00	6.02	8.00	9055240013200	
0.0551	1.40	32.00	6.90	9.00	9055240014000	
0.0591	1.50	32.00	6.75	9.00	9055240015000	
0.0594	1.51	34.00	7.74	10.00	9055240015100	
0.0626	1/16	1.59	34.00	7.62	10.00	9055240015900
0.0630	1.60	34.00	7.60	10.00	9055240016000	
0.0634	1.61	34.00	7.59	10.00	9055240016100	
0.0669	1.70	34.00	7.45	10.00	9055240017000	
0.0701	1.78	36.00	8.33	11.00	9055240017800	
0.0709	1.80	36.00	8.30	11.00	9055240018000	
0.0728	1.85	36.00	8.23	11.00	9055240018500	
0.0748	1.90	36.00	8.15	11.00	9055240019000	
0.0760	1.93	38.00	9.11	12.00	9055240019300	
0.0780	5/64	1.98	38.00	9.03	12.00	9055240019800
0.0783	1.99	38.00	9.02	12.00	9055240019900	
0.0787	2.00	38.00	9.00	12.00	9055240020000	
0.0811	2.06	38.00	8.91	12.00	9055240020600	
0.0819	2.08	38.00	8.88	12.00	9055240020800	
0.0827	2.10	38.00	8.85	12.00	9055240021000	
0.0858	2.18	40.00	9.73	13.00	9055240021800	
0.0866	2.20	40.00	9.70	13.00	9055240022000	
0.0890	2.26	40.00	9.61	13.00	9055240022600	
0.0906	2.30	40.00	9.55	13.00	9055240023000	
0.0933	2.37	43.00	10.45	14.00	9055240023700	
0.0937	3/32	2.38	43.00	10.43	14.00	9055240023800
0.0945	2.40	43.00	10.40	14.00	9055240024000	
0.0961	2.44	43.00	10.34	14.00	9055240024400	
0.0980	2.49	43.00	10.27	14.00	9055240024900	
0.0984	2.50	43.00	10.25	14.00	9055240025000	
0.0996	2.53	43.00	10.21	14.00	9055240025300	
0.1016	2.58	43.00	10.13	14.00	9055240025800	

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr mm	mm				
0.1024		2.60	43.00	10.10	14.00	9055240026000
0.1039		2.64	43.00	10.04	14.00	9055240026400
0.1063		2.70	46.00	11.95	16.00	9055240027000
0.1067		2.71	46.00	11.94	16.00	9055240027100
0.1094	7/64	2.78	46.00	11.83	16.00	9055240027800
0.1098		2.79	46.00	11.82	16.00	9055240027900
0.1102		2.80	46.00	11.80	16.00	9055240028000
0.1110		2.82	46.00	11.77	16.00	9055240028200
0.1130		2.87	46.00	11.70	16.00	9055240028700
0.1142		2.90	46.00	11.65	16.00	9055240029000
0.1161		2.95	46.00	11.58	16.00	9055240029500
0.1181		3.00	46.00	11.50	16.00	9055240030000
0.1201		3.05	49.00	13.43	18.00	9055240030500
0.1220		3.10	49.00	13.35	18.00	9055240031000
0.1248	1/8	3.17	49.00	13.25	18.00	9055240031700
0.1260		3.20	49.00	13.20	18.00	9055240032000
0.1283		3.26	49.00	13.11	18.00	9055240032600
0.1299		3.30	49.00	13.05	18.00	9055240033000
0.1339		3.40	52.00	14.90	20.00	9055240034000
0.1358		3.45	52.00	14.83	20.00	9055240034500
0.1378		3.50	52.00	14.75	20.00	9055240035000
0.1406	9/64 #28	3.57	52.00	14.65	20.00	9055240035700
0.1417		3.60	52.00	14.60	20.00	9055240036000
0.1441		3.66	52.00	14.51	20.00	9055240036600
0.1457		3.70	52.00	14.45	20.00	9055240037000
0.1469		3.73	52.00	14.41	20.00	9055240037300
0.1496		3.80	55.00	16.30	22.00	9055240038000
0.1520		3.86	55.00	16.21	22.00	9055240038600
0.1535		3.90	55.00	16.15	22.00	9055240039000
0.1539		3.91	55.00	16.14	22.00	9055240039100
0.1563	5/32	3.97	55.00	16.05	22.00	9055240039700
0.1571		3.99	55.00	16.02	22.00	9055240039900
0.1575		4.00	55.00	16.00	22.00	9055240040000
0.1591		4.04	55.00	15.94	22.00	9055240040400
0.1610		4.09	55.00	15.87	22.00	9055240040900
0.1614		4.10	55.00	15.85	22.00	9055240041000
0.1654		4.20	55.00	15.70	22.00	9055240042000
0.1661		4.22	55.00	15.67	22.00	9055240042200
0.1693		4.30	58.00	17.55	24.00	9055240043000
0.1720	11/64	4.37	58.00	17.45	24.00	9055240043700
0.1728		4.39	58.00	17.42	24.00	9055240043900

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.1732		4.40	58.00	17.40	24.00	9055240044000
0.1772		4.50	58.00	17.25	24.00	9055240045000
0.1799		4.57	58.00	17.15	24.00	9055240045700
0.1811		4.60	58.00	17.10	24.00	9055240046000
0.1819		4.62	58.00	17.07	24.00	9055240046200
0.1850		4.70	58.00	16.95	24.00	9055240047000
0.1874	3/16	4.76	62.00	18.86	26.00	9055240047600
0.1890		4.80	62.00	18.80	26.00	9055240048000
0.1909		4.85	62.00	18.73	26.00	9055240048500
0.1929		4.90	62.00	18.65	26.00	9055240049000
0.1937		4.92	62.00	18.62	26.00	9055240049200
0.1961		4.98	62.00	18.53	26.00	9055240049800
0.1969		5.00	62.00	18.50	26.00	9055240050000
0.1992		5.06	62.00	18.41	26.00	9055240050600
0.2008		5.10	62.00	18.35	26.00	9055240051000
0.2012		5.11	62.00	18.34	26.00	9055240051100
0.2031	13/64	5.16	62.00	18.26	26.00	9055240051600
0.2039		5.18	62.00	18.23	26.00	9055240051800
0.2047		5.20	62.00	18.20	26.00	9055240052000
0.2055		5.22	62.00	18.17	26.00	9055240052200
0.2087		5.30	62.00	18.05	26.00	9055240053000
0.2091		5.31	66.00	20.04	28.00	9055240053100
0.2126		5.40	66.00	19.90	28.00	9055240054000
0.2130		5.41	66.00	19.89	28.00	9055240054100
0.2165		5.50	66.00	19.75	28.00	9055240055000
0.2189	7/32	5.56	66.00	19.66	28.00	9055240055600
0.2205		5.60	66.00	19.60	28.00	9055240056000
0.2209		5.61	66.00	19.59	28.00	9055240056100
0.2244		5.70	66.00	19.45	28.00	9055240057000
0.2280		5.79	66.00	19.32	28.00	9055240057900
0.2283		5.80	66.00	19.30	28.00	9055240058000
0.2323		5.90	66.00	19.15	28.00	9055240059000
0.2339	A	5.94	66.00	19.09	28.00	9055240059400
0.2343	15/64	5.95	66.00	19.08	28.00	9055240059500
0.2362		6.00	66.00	19.00	28.00	9055240060000
0.2378	B	6.04	70.00	21.94	31.00	9055240060400
0.2402		6.10	70.00	21.85	31.00	9055240061000
0.2421	C	6.15	70.00	21.78	31.00	9055240061500
0.2441		6.20	70.00	21.70	31.00	9055240062000
0.2461	D	6.25	70.00	21.63	31.00	9055240062500
0.2480		6.30	70.00	21.55	31.00	9055240063000
0.2500	1/4	6.35	70.00	21.48	31.00	9055240063500
0.2520		6.40	70.00	21.40	31.00	9055240064000
0.2559		6.50	70.00	21.25	31.00	9055240065000
0.2571	F	6.53	70.00	21.21	31.00	9055240065300
0.2598		6.60	70.00	21.10	31.00	9055240066000
0.2610	G	6.63	70.00	21.06	31.00	9055240066300
0.2638		6.70	70.00	20.95	31.00	9055240067000
0.2657	17/64	6.75	74.00	23.88	34.00	9055240067500
0.2677		6.80	74.00	23.80	34.00	9055240068000
0.2717	I	6.90	74.00	23.65	34.00	9055240069000
0.2756		7.00	74.00	23.50	34.00	9055240070000
0.2768	J	7.03	74.00	23.46	34.00	9055240070300
0.2795		7.10	74.00	23.35	34.00	9055240071000
0.2811	9/32	7.14	74.00	23.29	34.00	9055240071400
0.2835		7.20	74.00	23.20	34.00	9055240072000
0.2874		7.30	74.00	23.05	34.00	9055240073000
0.2902	L	7.37	74.00	22.95	34.00	9055240073700
0.2913		7.40	74.00	22.90	34.00	9055240074000
0.2949	M	7.49	74.00	22.77	34.00	9055240074900
0.2953		7.50	74.00	22.75	34.00	9055240075000
0.2969	19/64	7.54	79.00	25.69	37.00	9055240075400
0.2992		7.60	79.00	25.60	37.00	9055240076000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.3020	N	7.67	79.00	25.50	37.00	9055240076700
0.3031		7.70	79.00	25.45	37.00	9055240077000
0.3071		7.80	79.00	25.30	37.00	9055240078000
0.3110		7.90	79.00	25.15	37.00	9055240079000
0.3126	5/16	7.94	79.00	25.09	37.00	9055240079400
0.3150		8.00	79.00	25.00	37.00	9055240080000
0.3161	O	8.03	79.00	24.96	37.00	9055240080300
0.3189		8.10	79.00	24.85	37.00	9055240081000
0.3228	P	8.20	79.00	24.70	37.00	9055240082000
0.3268		8.30	79.00	24.55	37.00	9055240083000
0.3280	21/64	8.33	79.00	24.51	37.00	9055240083300
0.3307		8.40	79.00	24.40	37.00	9055240084000
0.3319	Q	8.43	79.00	24.36	37.00	9055240084300
0.3346		8.50	79.00	24.25	37.00	9055240085000
0.3386		8.60	84.00	27.10	40.00	9055240086000
0.3390	R	8.61	84.00	27.09	40.00	9055240086100
0.3425		8.70	84.00	26.95	40.00	9055240087000
0.3437	11/32	8.73	84.00	26.91	40.00	9055240087300
0.3465		8.80	84.00	26.80	40.00	9055240088000
0.3480	S	8.84	84.00	26.74	40.00	9055240088400
0.3504		8.90	84.00	26.65	40.00	9055240089000
0.3543		9.00	84.00	26.50	40.00	9055240090000
0.3579	T	9.09	84.00	26.37	40.00	9055240090900
0.3583		9.10	84.00	26.35	40.00	9055240091000
0.3594	23/64	9.13	84.00	26.31	40.00	9055240091300
0.3622		9.20	84.00	26.20	40.00	9055240092000
0.3661		9.30	84.00	26.05	40.00	9055240093000
0.3677	U	9.34	84.00	25.99	40.00	9055240093400
0.3701		9.40	84.00	25.90	40.00	9055240094000
0.3740		9.50	84.00	25.75	40.00	9055240095000
0.3748	3/8	9.52	89.00	28.72	43.00	9055240095200
0.3772	V	9.58	89.00	28.63	43.00	9055240095800
0.3780		9.60	89.00	28.60	43.00	9055240096000
0.3819		9.70	89.00	28.45	43.00	9055240097000
0.3858	W	9.80	89.00	28.30	43.00	9055240098000
0.3898		9.90	89.00	28.15	43.00	9055240099000
0.3906	25/64	9.92	89.00	28.12	43.00	9055240099200
0.3937		10.00	89.00	28.00	43.00	9055240100000
0.3969	X	10.08	89.00	27.88	43.00	9055240100800
0.3976		10.10	89.00	27.85	43.00	9055240101000
0.4016		10.20	89.00	27.70	43.00	9055240102000
0.4039	Y	10.26	89.00	27.61	43.00	9055240102600
0.4055		10.30	89.00	27.55	43.00	9055240103000
0.4063	13/32	10.32	89.00	27.52	43.00	9055240103200
0.4094		10.40	89.00	27.40	43.00	9055240104000
0.4130	Z	10.49	89.00	27.27	43.00	9055240104900
0.4134		10.50	89.00	27.25	43.00	9055240105000
0.4220	27/64	10.72	95.00	30.92	47.00	9055240107200
0.4331		11.00	95.00	30.50	47.00	9055240110000
0.4374	7/16	11.11	95.00	30.34	47.00	9055240111100
0.4528		11.50	95.00	29.75	47.00	9055240115000
0.4531	29/64	11.51	95.00	29.74	47.00	9055240115100
0.4689	15/32	11.91	102.00	33.14	51.00	9055240119100
0.4724		12.00	102.00	33.00	51.00	9055240120000
0.4843	31/64	12.30	102.00	32.55	51.00	9055240123000
0.4921		12.50	102.00	32.25	51.00	9055240125000
0.5000	1/2	12.70	102.00	31.95	51.00	9055240127000
0.5118		13.00	102.00	31.50	51.00	9055240130000
0.5157	33/64	13.10	102.00	31.35	51.00	9055240131000
0.5311	17/32	13.49	107.00	33.77	54.00	9055240134900
0.5315		13.50	107.00	33.75	54.00	9055240135000
0.5512		14.00	107.00	33.00	54.00	9055240140000
0.5626	9/16	14.29	111.00	34.57	56.00	9055240142900

Stub Length